

Work Order ID 160896

160896

Page 1

Friday, May 05, 2017 9:44:28 AM

Item ID: PB67-43001-17

Accept

N900040100

Setup Start *NS1*

Revision ID:

DAS
21
9-89

Stop *NS2*

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/15/2017 Start Qty: 7.00

7

Cust Item ID:

Required Date: 5/29/2017 Req'd Qty: 7.00

7

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan:

DAS
21
9-89

Date:

MAY 05 2017

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001-17	D

100 Weld per dwg A/R Aluminum rod Batch: 136158 0.00

100

Large Fab

Large Fab

Memo

2.94

1- Make a 0.090" chamfer in the 1.00" hole before welding

2- Grind weld flush in area of PB67-43001-249 only

3- Assemble and weld as per dwg

2

JUN 06 2017

DAS
24
9-89

102

0.00

102

Mill Conv

Conventional Milling Machine

Memo

4.51

DRILL AND TAP FOR 1/2"-20 HELICAL INSERT

INSTALL HELICAL INSERT

2

Ø

DAS
32
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 160896***160896***

Page 2

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 5/15/2017 Start Qty: 7.00 ***7***

Cust Item ID:

Required Date: 5/29/2017 Req'd Qty: 7.00 ***7***

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105	QC5- Inspect part completeness to step on W/O	0.00							
105						(2)	17-06-12		DAS 9 9-89
QC	Memo	0.14							
Quality Control									
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110						(2)	17-06-12		DAS 9 9-89
QC	Memo	0.14							
Quality Control									
160	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
160	<i>N 131092.</i>					2	17-06-14.		DAS 34 9-89
Powdercoat	Memo	1.70							
Powder Coating	1- MASK TUBE FROM BASE TO GUSSET								

START TIME: 1:45.OVEN TEMPERATURE: 300FINISH TIME: 2:15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Misidentified ☐	Past Due ☐																																																																

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
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				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

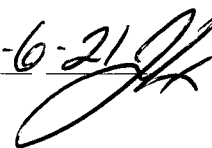
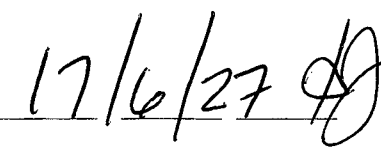
Work Order ID 160896***160896***

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Friday, May 05, 2017 9:44:28 AM

Item ID: PB67-43001-17 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Adjustable Blade Support Assembly
Start Date: 5/15/2017 Start Qty: 7.00 ***7*** Cust Item ID:
Required Date: 5/29/2017 Req'd Qty: 7.00 ***7*** Customer:
Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>WAC03</u>	0.00				2	0	17-6-21	
200									
Packaging	Memo	0.07							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00						17/6/27	
210									
QC	Memo	0.70							
Quality Control									


JUN 23 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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Root Cause		FAULT CATEGORY																							
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OTHER : ☐																									

Picklist Print

Friday, May 05, 2017 9:44:27 AM

Page 1

Work Order ID: 160896

160896

Parent Item: PB67-43001-17

PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/15/2017

Required Date: 5/29/2017

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.28 per rev C dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS124780		Purchased	No			180	Each	12.0000	1	7			DAS 32 9-89
MS124780									**			02-06-12	
HELICAL INSERT													

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST316	12								
				111064	12								
MS27039-1-10		Purchased	No			180	Each	287.0000	8	56			DAS 19 9-89
MS27039-1-10									**			JUN 19 2017	
SCREW													

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				GA	15								
				m129541	15								
				ST280	272								
				m137164	272								
NAS1149D0316J		Purchased	No			180	Each	1,053.000	8	56			DAS 19 9-89
NAS1149D0316J									**			JUN 19 2017	
Washer													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST264	1053	
M134502	1053	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Picklist Print

Page 2

Friday, May 05, 2017 9:44:27 AM

Work Order ID: 160896

160896

Parent Item: PB67-43001-17

PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/15/2017

Required Date: 5/29/2017

Start Qty: 7.00

Required Qty: 7.00

NAS1149D0363J

Purchased

No

180

Each

629.0000

NAS1149D0363.1

Washer

Start Date: 5/15/2017
Start Qty: 7.00
** 6 50
42

JUN 19 2017

DAS
19
9-89

Location	Loc Qty	Loc Code
GA	42	
m134055	42	
ST263	587	
m137061	100	
m137164	487	

12

PB67-43001-249

Manufactured

No

100

Each

4.0000

1

7

DAS
24
9-89

PR67-43001-249

Inner Tube Bushing

** JUN 06 2017

Location	Loc Qty	Loc Code
WA003	4	
133726	4	

PB67-43001-253

Manufactured

No

100

Each

0.0000

1

7

JUN 06 2017

DAS
24
9-89
DAS
24
9-89

PR67-43001-253

Gusset

** B160822 -> 2

PB67-43001-254

Manufactured

No

100

Each

0.0000

1

7

JUN 06 2017

PR67-43001-254

Gusset

** B160819 -> 2

PB67-43001-259

Manufactured

No

100

Each

0.0000

1

7

JUN 06 2017

DAS
24
9-89

PR67-43001-259

Inner Tube

** B160815 -> 2

PB67-43001-71

Manufactured

No

180

Each

1.0000

1

7

JUN 06 2017

DAS
24
9-89

PR67-43001-71

20° Blade Support Assembly

**

Location	Loc Qty	Loc Code
Mezz2	1	
152104	1	

B160830 -> 2

Friday, May 05, 2017 9:44:27 AM

Shop Packet Print

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DQA: _____ Date: _____

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OTHER : _____																																																																				

Picklist Print

Page 3

Friday, May 05, 2017 9:44:27 AM

Work Order ID: 160896

160896

Parent Item: PB67-43001-17

PR67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/15/2017

Required Date: 5/29/2017

Start Qty: 7.00

Required Qty: 7.00

DAS

19

9-88

PB67-43001-73

Manufactured No

180

Each

12.0000

1

7

PR67-43001-73

20 Degree Cover Plate

**

~~487-51-NAC~~ JUN 15 2017

Location

Loc Qty

Loc Code

Mezz2

2

138692

2

WA003

10

156064

10

PB67-43001-83

Manufactured No

180

Each

6.0000

1

7

PR67-43001-83

D-Pad Assembly, Short

**

JUN 19 2017

DAS

19

9-88

Location

Loc Qty

Loc Code

Mezz2

6

138687

6

160825

2

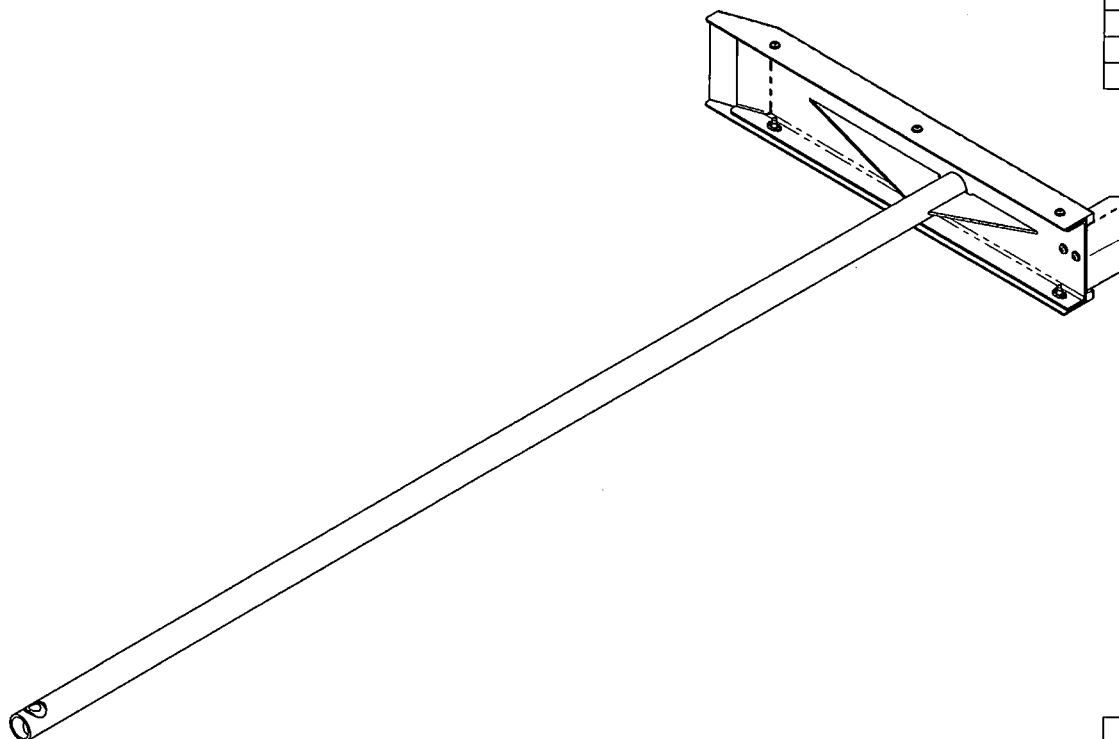
DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
Root Cause				FAULT CATEGORY																					
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Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____																					
Misidentified ☐		Past Due ☐																							



B67-43001-17 AFT ADJUSTABLE BLADE SUPPORT ASSY

RELEASED
2016-11-09
Gw16-655

ITEM	QTY -17	P/N	DESCRIPTION
1	X	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-17W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-73	20° COVER PLATE
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER
8	1	MS124780	HELI-COIL INSERT

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160896MUS.

1705-05

D	MERGE B67-43001-17W WITH B67-43001-17, REASON PAR15-437	SAD	16.11.14
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	10.04.28
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-17	SHEET 1 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT WELDMENT	NTS
DATE	16.11.14	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

8 7 6 5 4 3 2 1

D
C
B
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D
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B67-43001-17W AFT ADJUSTABLE
BLADE SUPPORT WELDMENT
REF

NAS1149D0363J
WASHER

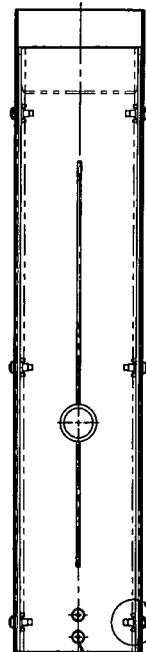
MS27039-1-10 SCREW 8
NAS1149JD0316J WASHER

B67-43001-73
20° COVER PLATE
REF

SECTION A-A B7-2
SCALE 4X, 6 PL

B67-43001-73
20° COVER PLATE

B67-43001-17W AFT ADJUSTABLE
BLADE SUPPORT WELDMENT



MS27039-1-10 SCREW
NAS1149JD0316J WASHER
2 PL 8

B67-43001-17 AFT ADJUSTABLE BLADE SUPPORT ASSY

B67-43001-83
D-PAD ASSEMBLY, SHORT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.09 lbs
- 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\phi 0.250$ TO $\phi 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-17W AND B67-43001-83 TO B67-43001-73

RELEASED
2016-11-09

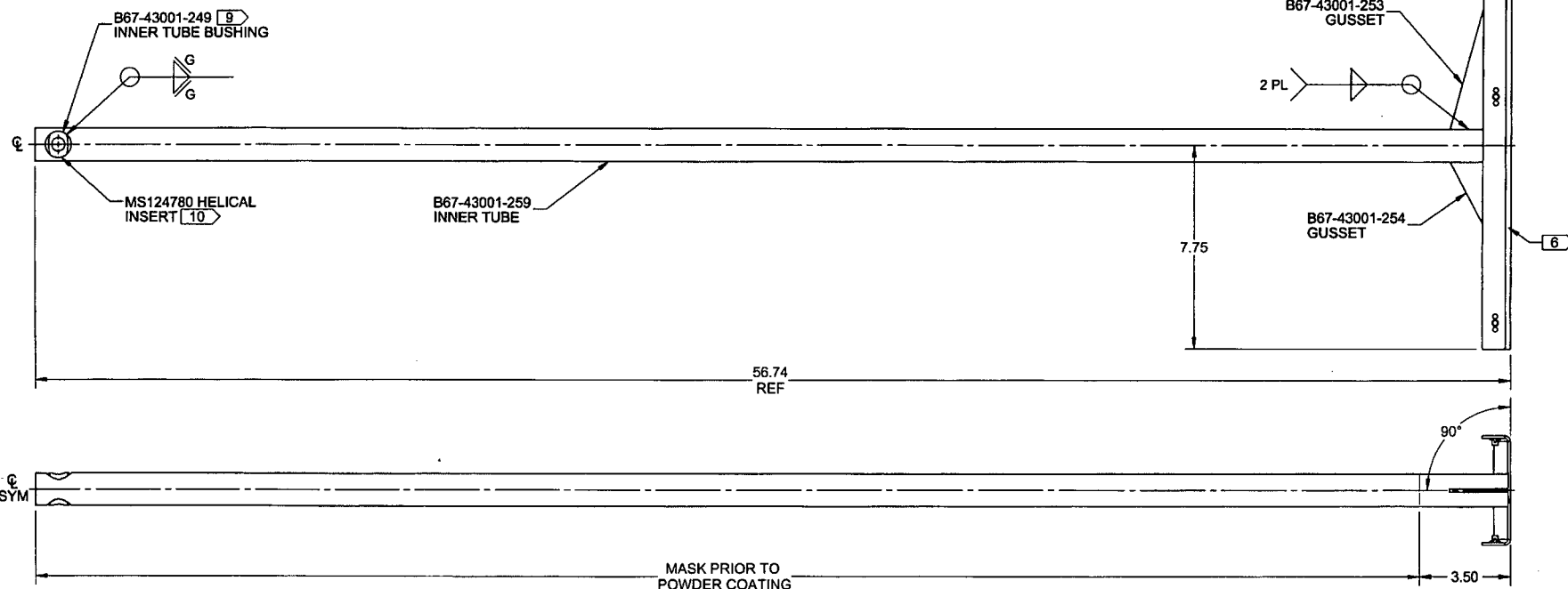
APPROVED

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-17	SHEET 2 OF 3
APPROVED	WM	TITLE	AFT ADJUSTABLE BLADE
DE APPR.	N/A	SUPPORT WELDMENT	SCALE
DATE	16.11.14		NTS

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8 7 6 5 4 3 2 1

ITEM	QTY -17W	P/N	DESCRIPTION
1	X	B67-43001-17W	AFT ADJUSTABLE BLADE SUPPORT WELMENT
2	1	B67-43001-71	20-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-249	INNER TUBE BUSHING
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-259	INNER TUBE
7	1	MS124780	HELICAL INSERT



B67-43001-17W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREEN SANDEXT" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-17W" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.74 lbs
- 8) WELDING: PER QSI 004
- 9) GRIND B67-43001-249 BUSHING AND WELD TO CONTOUR OF TUBE IN ACCORDANCE WITH NOTE 8
- 10) INSTALL HELICAL INSERT PER MS33537

RELEASED
2016-11-09

APPROVED

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	DD	B67-43001-17	SHEET 3 OF 3
APPROVED	WM	TITLE	AFT ADJUSTABLE BLADE
DE APPR.	N/A	SUPPORT WELDMENT	
DATE	16.11.14	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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